

Amendments to the Claims:

This listing of claims replaces all prior versions and listings of claims in the application:

Listing of Claims:

1. (Canceled)
2. (Previously Presented) A web fed printing press comprising:
at least one flexographic printing module equipped to apply variable amounts of motion and tension to a web substrate;
at least one intaglio printing module equipped to apply variable amounts of motion and tension to said web substrate; and
means for controlling the amounts of motion and tension applied by the flexographic printing module and by the intaglio printing module to said web substrate,
wherein the at least one flexographic printing module and the at least one intaglio printing module are arranged so that flexographic and intaglio printing can occur simultaneously on a web substrate.
3. (Previously Presented) The web fed printing press according to claim 2, wherein said means for controlling the amounts of motion and tension applied to said web substrate by said at least one flexographic printing module and by said at least one intaglio printing module comprises a host processor and first and second motion control processors.
4. (Previously Presented) The web fed printing press according to claim 3, wherein the first motion control processor controls the amounts of motion and tension imparted to the web substrate by the intaglio printing module.

5. (Previously Presented) The web fed printing press according to claim 3, wherein said first motion control processor generates a plurality of timing signals and the second motion control processor utilizes said timing signals to control the amounts of motion and tension imparted to the web substrate by the flexographic printing module.

6. (Original) The web fed printing press according to claim 3, wherein the means for controlling the amounts of motion and tension applied by the intaglio printing module to said web substrate further comprises a reference encoder, said reference encoder generating a reference signal corresponding to the motion of said web substrate.

7. (Previously Presented) The web fed printing press according to claim 6, wherein the first motion control processor utilizes the reference signal generated by the reference-controller to control the amounts of motion and tension imparted to the web substrate by the intaglio printing module.

8. (Original) The web fed printing press according to claim 2, wherein said means for controlling the amounts of motion and tension applied by the flexographic printing module and by the intaglio printing module to said web substrate further comprises at least one servo motor on said at least one intaglio printing module and at least one servo motor on said at least one flexographic printing module.

9. (Previously Presented) The web fed printing press according to claim 8, wherein said at least one servo motor on said at least one intaglio printing module is mechanically connected to said web substrate and electrically connected to said first motion control processor.

10. (Previously Presented) The web fed printing press according to claim 8, wherein said at least one servo motor on said at least one flexographic printing module is mechanically

connected to said web substrate and is electrically connected to said second motion control processor.

11. (Previously Presented) The web fed printing press according to claim 3, wherein said first motion control processor is mounted in a first RISC based motion control board and said second motion control processor is mounted in a second RISC based motion control board.

12. (Previously Presented) The web fed printing press according to claim 2, wherein said at least one flexographic printing module precedes said at least one intaglio printing module.

13. (Original) The web fed printing press according to claim 2, wherein means for bypassing said at least one intaglio printing module are provided.

14. (Previously Presented) The web fed printing press according to claim 13, wherein said means for bypassing said at least one intaglio printing module comprises a synthesized reference signal, said synthesized reference signal being utilized by a motion control processor to control the amounts of motion and tension imparted to the web substrate by said at least one flexographic printing module.

15. (Previously Presented) The web fed printing press of claim 2 wherein the at least one flexographic printing module and the at least one intaglio printing module are arranged so that, during operation of the web fed printing press, the web substrate passes through the at least one flexographic printing module before passing through the at least one intaglio printing module.

16. (Previously Presented) The web fed printing press of claim 15 wherein the web substrate's motion through the at least one flexographic printing module is substantially

continuous and wherein the web substrate's motion through the at least one intaglio printing module is intermittent.

17. (Previously Presented) The web fed printing press of claim 16 further comprising:
at least one servo arranged to move the web substrate through the at least one flexographic printing module; and
at least one servo arranged to move the web substrate through the at least one intaglio printing module.

18. (Previously Presented) The web fed printing press of claim 17 wherein the intaglio printing module comprises:
an intaglio plate cylinder;
a first servo arranged to pull the web substrate from the at least one flexographic printing module in a continuous manner;
a first vacuum box arranged to receive the web substrate from the first servo;
a second servo arranged to transport the web substrate from the first vacuum box to the intaglio plate cylinder;
a third servo to pull the web substrate from the intaglio plate cylinder;
a second vacuum box arranged to receive the web fed substrate from the third servo; and
a fourth servo to pull the web substrate from the second vacuum box in a substantially continuous manner.

19. (Previously Presented) The web fed printing press of claim 18 wherein the second and third servos are operable relative to one another to create tension in the web substrate at the intaglio plate cylinder.

20. (Previously Presented) The web fed printing press of claim 17 further comprising:

an optical encoder coupled to the intaglio unit and adapted to generate a motion reference signal; and

a motion controller to control the at least one servo arranged to move the web substrate through the at least one flexographic printing module and the at least one servo arranged to move the web substrate through the at least one intaglio printing module,

wherein the motion controller controls based, at least in part, on the motion reference signal.

21. (Previously Presented) The web fed printing press of claim 2 wherein the at least one flexographic printing module and the at least one intaglio printing module are arranged so that flexographic and intaglio printing can occur at different times on the web substrate.

22. (Canceled)

23. (Previously Presented) A web fed printing press comprising:
at least one flexographic printing module;
at least one intaglio printing module;
a controller to control motion of a web substrate through the flexographic printing module and the intaglio printing module,

wherein the at least one flexographic printing module comprises at least one servo to move the web substrate through the at least one flexographic printing module in a continuous manner;

wherein the at least one intaglio printing module comprises:

- an intaglio plate cylinder;
- a first servo arranged to pull the web substrate from the at least one flexographic printing module in a continuous manner;
- a first vacuum box arranged to receive the web substrate from the first servo;

a second servo arranged to transport the web substrate from the first vacuum box to the intaglio plate cylinder using intermittent motion;

a third servo to pull the web substrate from the intaglio plate cylinder, wherein the third servo is operable relative to the second servo to create tension in the web substrate at the intaglio plate cylinder;

a second vacuum box arranged to receive the web fed substrate from the third servo; and

a fourth servo to pull the web substrate from the second vacuum box in a substantially continuous manner;

wherein the at least one flexographic printing module and the at least one intaglio printing module are arranged so that flexographic and intaglio printing can occur simultaneously on a web substrate.